

Work Order ID 54451




December 9, 2009 11:30:59 AM

Page 1

Item ID: D3370-051 Accept  Setup Start 
Revision ID: Stop 
Item Name: Pedal Lock Assembly
Start Date: 09/12/2009 Start Qty: 4.00  Cust Item ID:
Required Date: 16/12/2009 Req'd Qty: 4.00  Customer:

Reference:

Approvals: Process Plan: RI Date: 09-12-9 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3370	Rev C								
100	Small Fab	0.00							
	Small Fab	0.00							
Small Fab	Memo								
Small Fab	Assemble as per dwg D3370								
110	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
Quality Control	Memo								
120	Identify as per dwg & Stock Location: <u>B58938</u>	0.00							
	Packaging	0.00							
Packaging	Memo								

SB 10/05/31

SB 10/06/31

SB 10/05/31

(4)

(4)

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54451

December 9, 2009 11:30:59 AM



Page 2

Item ID: D3370-051

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Assembly

Start Date: 09/12/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/31 *[Signature]*

MF

10-5-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

December 9, 2009 11:31:04 AM

Work Order ID: 54451

Parent Item: D3370-051

Parent Item Name: Pedal Lock Assembly

Start Date: 09/12/2009

Required Date: 16/12/2009

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
238-028		Purchased	No			100	Each	114.0000	8.0000			



3/16" Dowel Pin .5" long

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	114	
106673	85	
17278	29	

AN526C832R6

Purchased

No



Screw

100 Each 440.0000 16.0000

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	440	
16612	440	

D2728-7

Manufactured

No



Dart Logo label

D3370-1

Manufactured

No



Pedal Lock Base

100 Each 7.0000 4.0000

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	7	
37186	1	
47344	6	

SB 10/05/31

SB 10/05/31

SB 10/05/31

SB 10/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 9, 2009 11:31:05 AM

Work Order ID: 54451



Parent Item: D3370-051



Parent Item Name: Pedal Lock Assembly

Start Date: 09/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3370-3 Manufactured No 100 Each 7.0000 4.0000



Pedal Lock Cover

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

B 57364

ST

7

45792

6

47345

1

D3373-5 Manufactured No 100 Each 59.0000 4.0000



Cam Lock

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

B 22177

ST

59

22383

59

D3385-3 Manufactured No 100 Each 140.0000 4.0000



Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

140

22387

140

(4)

SB 10/05/31

(4)

SB 10/05/31

4

SB 10/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

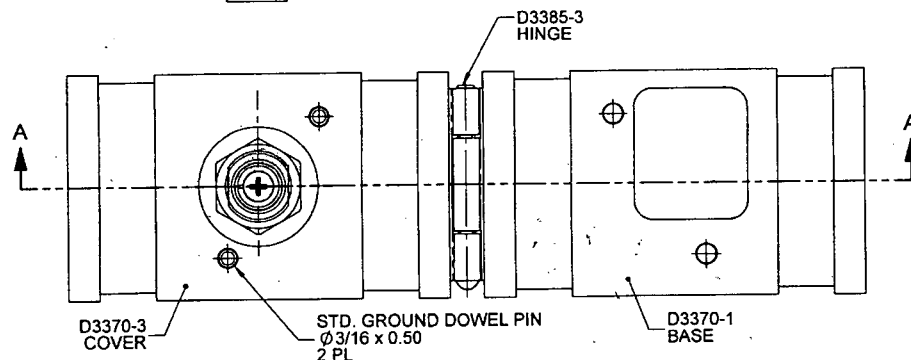
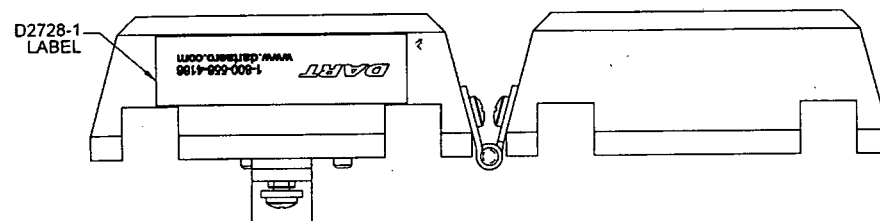
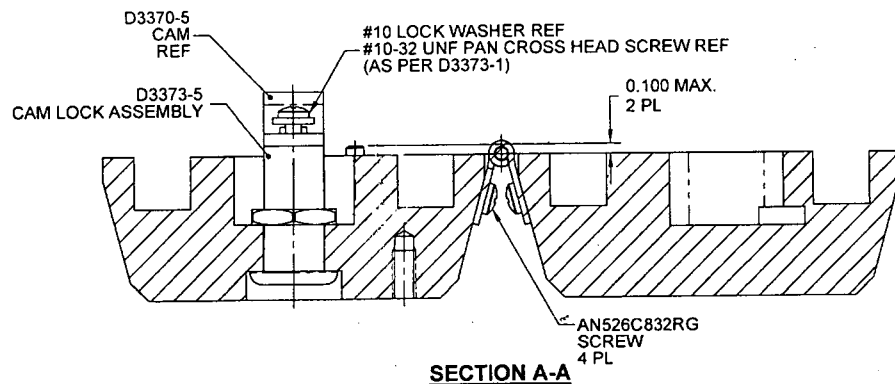
Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D3370-041	TAIL ROTOR DISABLING KIT
1	X	D3370-051	PEDAL LOCK
1		D3384-041	CYCLIC SOCK
1		HX-81	1/4-20 SOCKET HEAD CAP SCREW
2		AN960-416	WASHER
1		D2728-7	LABEL
1		D3370-1	BASE
1		D3370-3	COVER
1		D3373-5	CAM LOCK ASSY
1		D3385-3	HINGE
2		Ø 3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
4		AN526C832R6	SCREW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54451

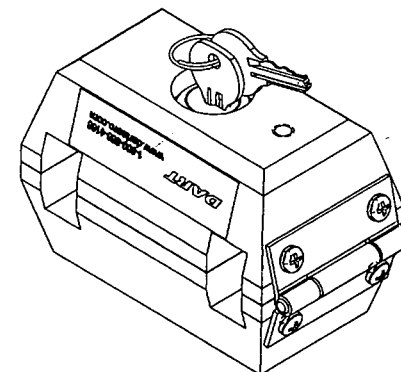
BL 08-12-9

RELEASED
08-07-16

C	SHEET 1 ADDED P/L. ADDED -041 TO P/L (SEE NCR 264). DRAWING TRANSFERRED TO "B" SIZE FORMAT. REFORMATTED TO CURRENT STANDARDS.		AJS	08.07.11
B	D3385-3 WAS D3385-1		MB	05.03.22
A	NEW ISSUE		RF	04.12.15
REV.	DESCRIPTION		BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		D3370	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		PEDAL LOCK	NTS	
DATE	08.07.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		



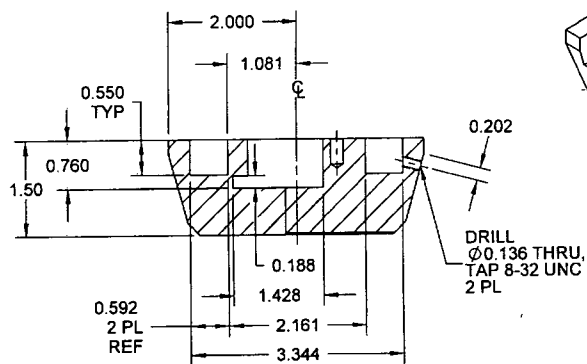
D3370-051 PEDAL LOCK ASSEMBLY



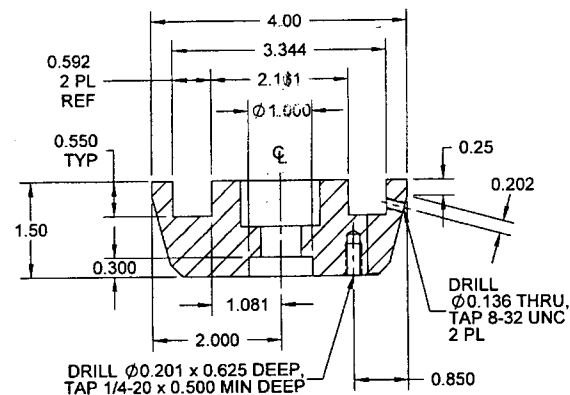
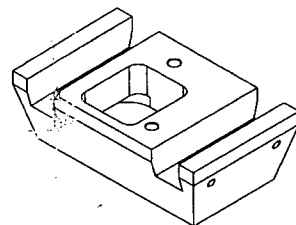
- NOTES:
- 1 MATERIAL: N/A
 - 2 FINISH: NONE
 - 3 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4 UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5 BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6 IDENTIFICATION: NONE
 - 7 WEIGHT: 0.75 lbs

RELEASED
08-07-11

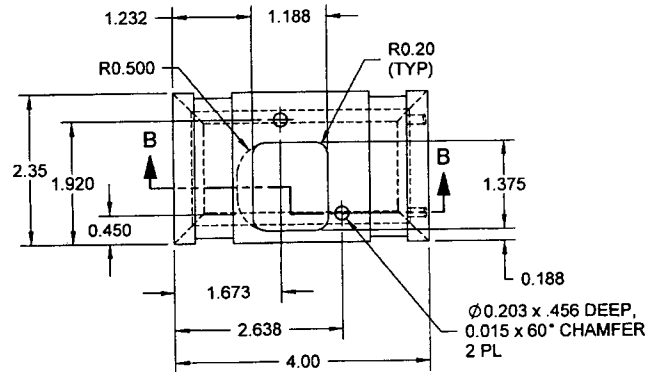
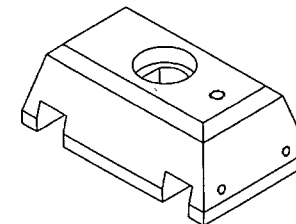
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DRAWN	AJS		
CHECKED	EZ	DRAWING NO.	REV. C
MFG. APPR.	MB	D3370	SHEET 2 OF 4
APPROVED	MB	TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
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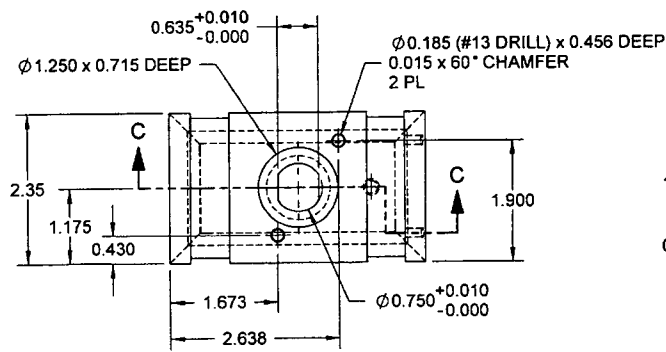
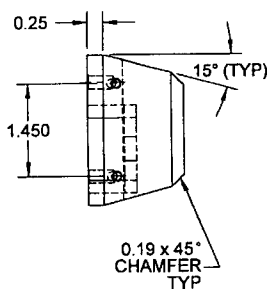
SECTION B-B



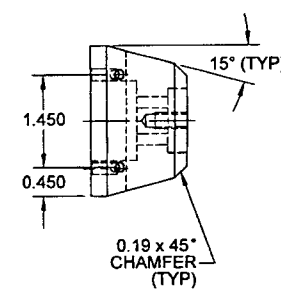
SECTION C-C



D3370-1 BASE



D3370-3 COVER



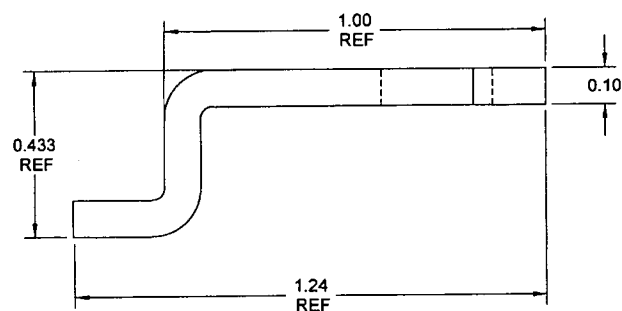
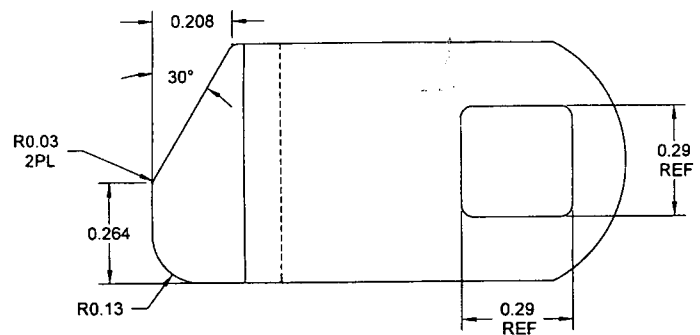
NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
REF. DART SPEC. M6061T6B
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

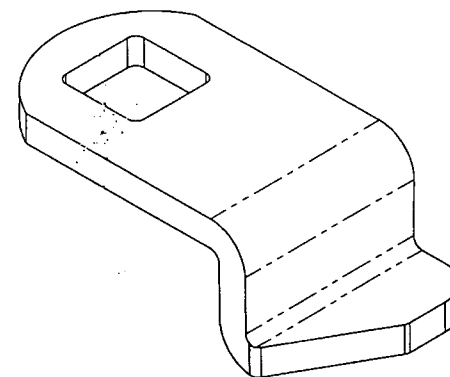
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3370	SHEET 3 OF 4
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DE APPR.		PEDAL LOCK	NTS
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RELEASED
08-07-16

W10 54451



D3370-5 CAM



NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
7601-14

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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